

Work Order ID 64085

Wednesday, November 24, 2010 8:48:39 AM



Page 1

Item ID: D3594-044

Accept



Setup Start



Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 11/24/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/11/24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3594	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

10-11-29

FLOW CNC Waterjet

1-Cut as per Dwg D3594 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

6061 . 680

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

10-11-29

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

10/11/29

10

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3594-044

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Stop

Item Name: Floor Doubler Assembly, RH

Start Date: 11/24/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

Small Fab

C'SINK AS PER DWG D3594

0.00

0.00

9510/11/29 (10)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

80462

(X10)
4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

=) 91 10/11/30

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64085

Page 3

Wednesday, November 24, 2010 8:48:39 AM

Item ID: D3594-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Doubler Assembly, RH

Start Date: 11/24/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 BR 10-11-30

170



Small Fab

Small Fab

Small Fab

Memo

Install Nut Plates As per Dwg D3594

0.00

0.00

E Bro / 11/30 10

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 12/1/11

410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64085

Wednesday, November 24, 2010 8:48:39 AM



Page 4

Item ID:	D3594-044	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Floor Doubler Assembly, RH					
Start Date:	11/24/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	11/30/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location <u>234B</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/12/25 (10x)

10/12/03 ME 10-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:48:43 AM

Page 1

Work Order ID: 64085

Parent Item: D3594-044

Parent Item Name: Floor Doubler Assembly, RH




Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD4-4  Rivet		Purchased	No			100	Each	3,551.000	2	20			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				521					
					15541			521					
				ST317				3030					
					116188			3030					
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No			170	sf	7.8150	0.51	5.368421			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				7.815					
					115689			7.815					
MS21069-5  Anchor nuts		Purchased	No			170	Each	50.0000	1	10			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				50					
					113725			35					
					114075			15					

20
E/S 10/11/30

20

1810-11-29

10

115689

10
E/S 10/11/30

10

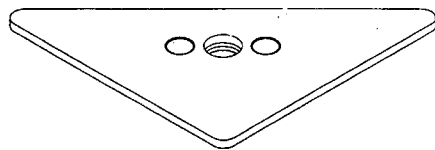
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

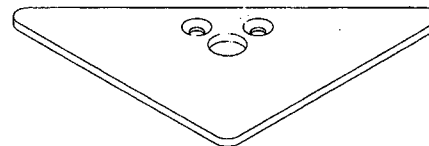
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

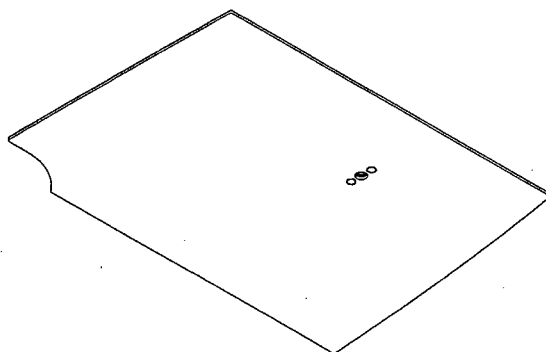
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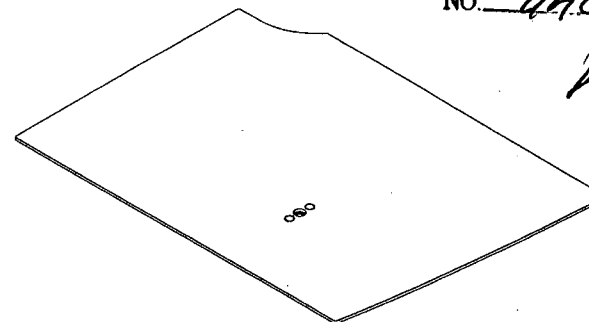
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

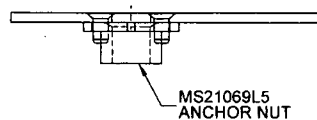
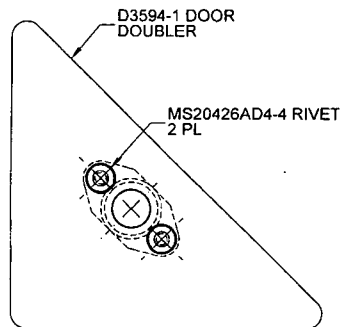
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44085

2810-11-24

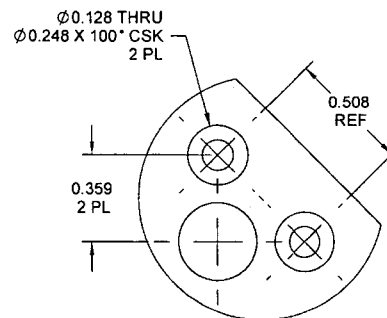
RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.		AJS	08.05.14
A	NEW ISSUE		MB	07.04.13
REV.	DESCRIPTION		BY	DATE
DESIGN	MB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 REV. B SHEET 1 OF 4 TITLE DOUBLER SCALE NTS DATE 08.05.14	
DRAWN	AJS			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>		<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

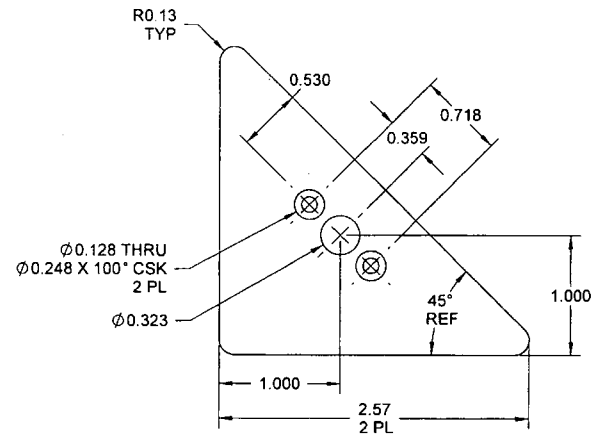
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



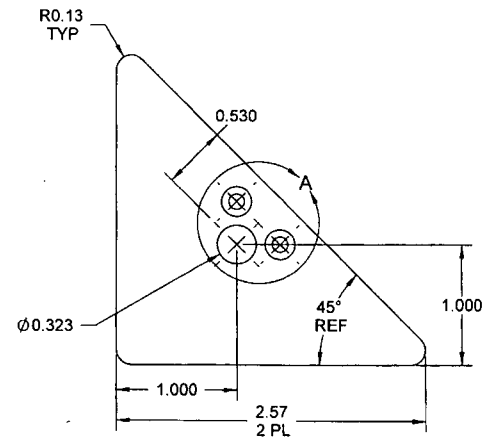
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

NOTES:

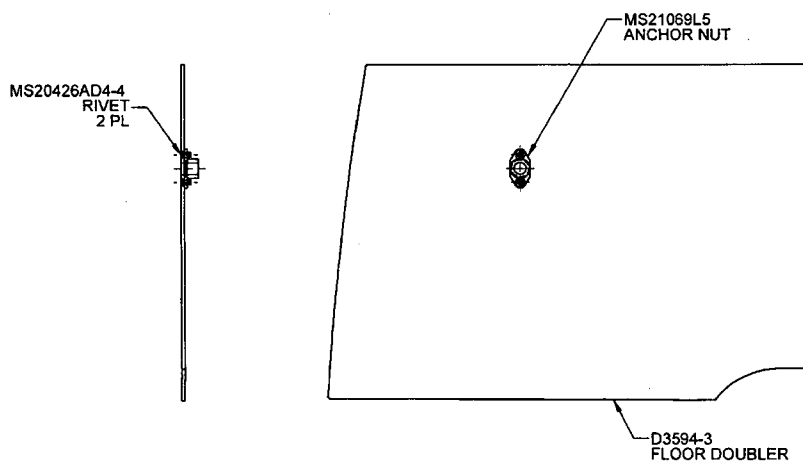
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE DOUBLER	SCALE NTS
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.05.14		

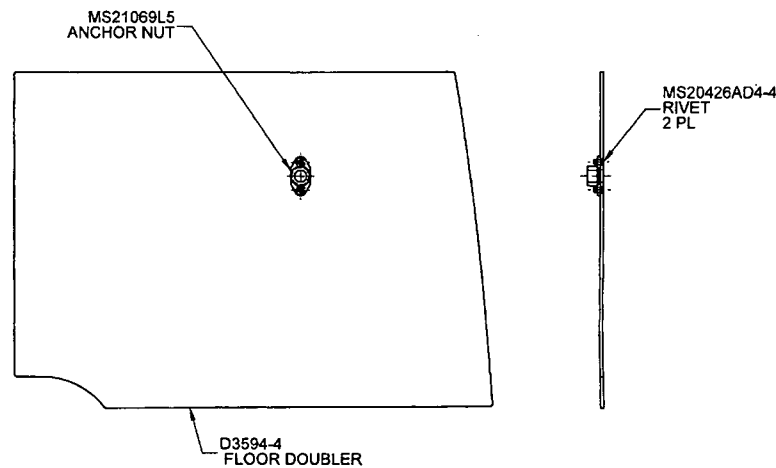
RELEASED
08-05-26-14

u/o 44085

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

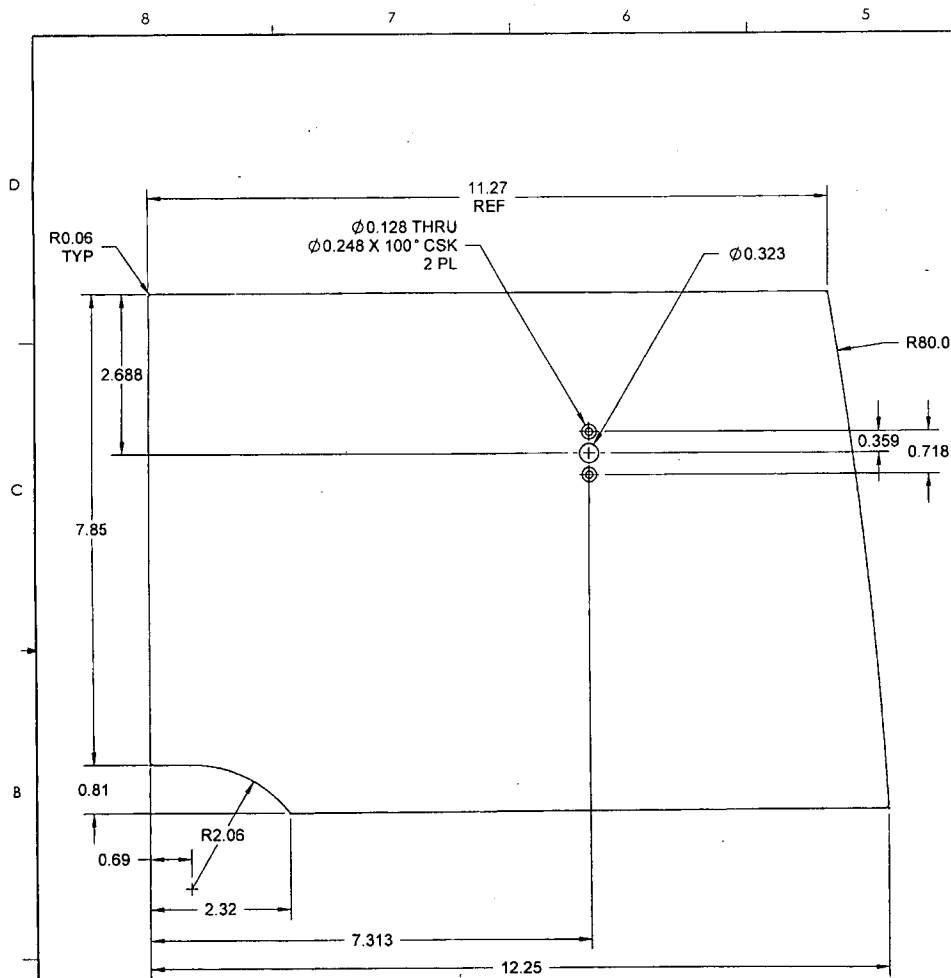
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

21064685

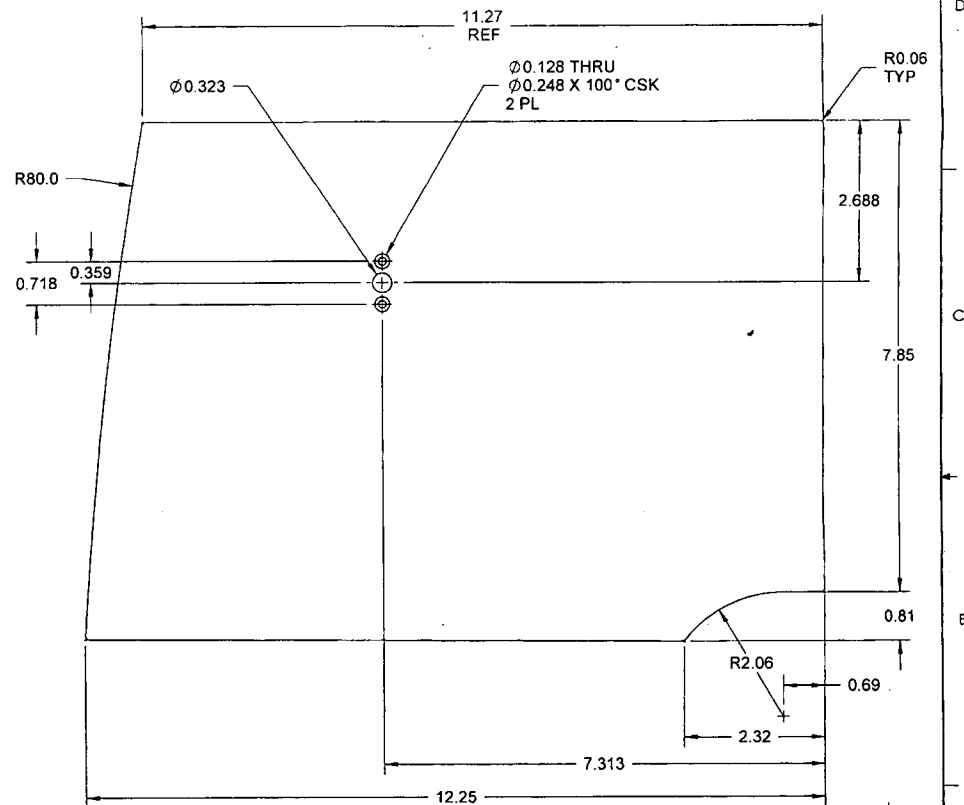
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08.05.14

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. 8
MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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D3594-3 FLOOR DOUBLER

w/64085



D3594-4 FLOOR DOUBLER

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08.05.14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3594	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR DOUBLER ASSEMBLY	NTS
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